

6A

Date: Thursday, 2/23/2006 10:16:57 AM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SADDLE FITTING, FWD (OUTBOARD/INBOARD)
Job Number : 25897	
Estimate Number : 10530	
P.O. Number : N/A	Part Number : D2571
This Issue : 2/23/2006 S.O. No. : N/A	Drawing Number : D2571 REV E
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : MACHINED PARTS	Drawing Revision : E
Previous Run : 25859	Material : N/A
Written By : <u>SEE COMMENT BELOW</u>	Due Date : 3/15/2006 Qty: 7 Um: Each
Checked & Approved By : <u>KG 06.02.23</u>	
Comment : Est: 1 02.10.02 Re-format; Change to Dwg Rev. D & incorporated D2572KJ	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6101007	7075-T7351 8.25X7.75X2.5
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)
7075-T7351 8.25X7.75X2.5
Make from D6101-007 billet for D2571
Ensure that grain is along 7.75" length
Batch No: B24093 46

EP 06/03/23 (7)

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1
Program Batch No. B25813 Double check by: WL

- 1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets
- 2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets
- 3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets
- 4-Deburr and remove all machining marks
- 5-Tumble to remove sharp edges.

EP / S.G. 06/03/25 7

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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Comment: CONVENTIONAL MILLING MACHINE
Machine keyway as per dwg D2571 & D2572

EP / S.G. 06/03/25 7

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

EP / S.G. 06/03/25 7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: DD Date: 06/07/30
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 2/23/2006 10:16:58 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE FITTING, FWD (OUTBOARD/INBOARD)

Job Number: 25897

Part Number: D2571

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

ml 06/03/28

7

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

a.m

06-03-28

(7)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

DL 06/03/28

(7)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

DL 06/03/28 (7)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *478*

DL 06/03/28 (7)

10.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

DL 06/03/30 (7)

Job Completion



DL 06-03-29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	25897
Description: Saddle, Fwd Outboard	Part Number:	D2571
Inspection Dwg: D2571 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443	DT8682	0.438	0.438	0.438	0.438		
B	1.745	1.755		1.747	1.747	1.747	1.747		
C	3.495	3.505		3.499	3.498	3.497	3.497		
D	1.745	1.755		1.747	1.747	1.747	1.747		
E	7.990	8.010		8.004	8.004	8.005	8.005		
F	0.490	0.510		0.500	0.499	0.504	0.504		
G	0.257	0.262	DT8683	0.257	0.257	0.257	0.257		
H	0.375	0.380	DT8684	0.375	0.375	0.375	0.375		
I	0.490	0.510		0.501	0.500	0.501	0.501		
J	1.174	1.184		1.177	1.177	1.178	1.178		
K	0.558	0.578		0.568	0.568	0.565	0.565		
L	1.174	1.184		1.177	1.177	1.178	1.178		
M	1.490	1.500		1.498	1.500	1.498	1.497		
N	2.495	2.505		2.501	2.501	2.496	2.497		
O	3.869	3.879		3.872	3.871	3.876	3.876		
P	0.115	0.135		0.128	0.127	0.128	0.127		
Q	0.115	0.135		0.130	0.130	0.130	0.130		
R	0.240	0.260		0.244	0.246	0.248	0.247		
S	0.115	0.135		0.128	0.127	0.127	0.126		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	2.940	2.980		2.961	2.962	2.961	2.960		
V	0.230	0.250		0.245	0.244	0.244	0.244		
W	0.115	0.135		0.125	0.127	0.121	0.122		
X	0.308	0.313		0.310	0.310	0.310	0.310		
Y	0.760	0.765		0.760	0.760	0.760	0.760		
Z	0.352	0.372		0.360	0.361	0.361	0.361		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.630	0.630	0.623	0.624		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.249	0.248	0.249	0.248		
AE	1.375	1.395		1.385	1.388	1.388	1.388		
AF	0.115	0.135		0.130	0.130	0.130	0.130		
AG	0.240	0.280		0.260	0.260	0.260	0.260		
AH	0.240	0.260		0.244	0.245	0.254	0.253		
AI	2.000	2.020		2.000	2.001	2.005	2.004		
AJ	0.023	0.043		0.030	0.030	0.030	0.030		
Accept/Reject									

Measured by:	J.G.
Date:	06/03/25

Audited by:	JRK
Date:	06/03/28

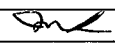
Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

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D	1.745	1.755		1.750	1.749	1.748			
E	7.990	8.010		8.001	8.002	8.004			
F	0.490	0.510		0.498	0.499	0.505			
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Y	0.760	0.765		0.760	0.760	0.761			
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AE	1.375	1.395		1.387	1.388	1.388			
AF	0.115	0.135		0.130	0.130	0.130			
AG	0.240	0.280		0.260	0.260	0.260			
AH	0.240	0.260		0.244	0.244	0.244			
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Measured by:	J. G.
Date:	06/03/27

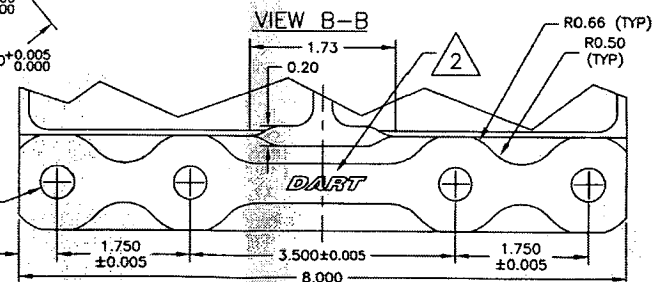
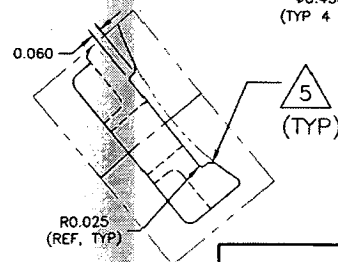
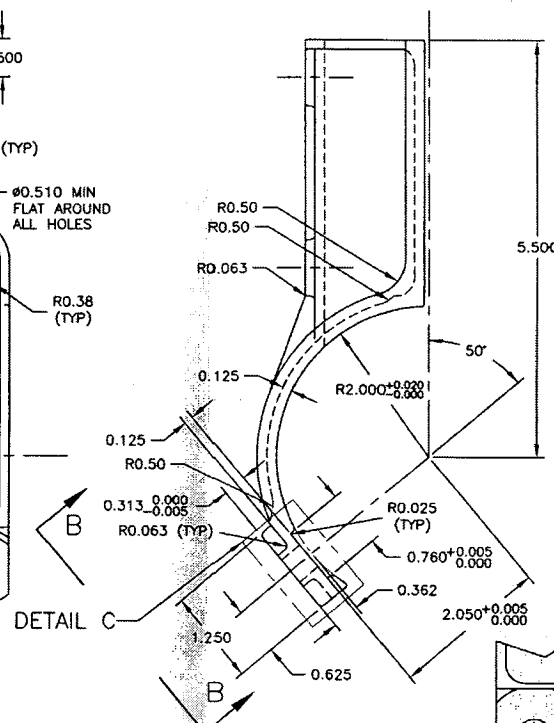
Audited by:	
Date:	06/03/28

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A		New Issue	RF	
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D	05.05.05	Added dimension AI	KJ/RF	
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05.12.06 

MATERIAL: 7075-17351 (QQ-A-250/12) (REF DART SPEC. D6102-001)
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART
QSI 005 4.3
BREAK ALL SHARP EDGES 0.010 TO 0.020
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

- 1 ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010
- 2 ENGRAVE PART LOGO TO MAX DEPTH OF 0.015 WITH MIN. RAD 0.125
- 3 CHAMFER 0.063" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES)
- 4 CHAMFER 0.063" x 45° ALL AROUND
- 5 CHAMFER 0.033" x 45° (SEE DETAIL C)



E	05.07.13	ADD CHAMFER ON RIDGE, NOTE 5
D	02.09.06	ADD RIDGES; TIGHTEN TOLERANCES
C	99.10.22	INCORP. DEO 9123/9079/9102 ADD DIMENSIONS PER TSR A1177
B	96.12.02	ADD GRAIN DIR., 0.438 WAS 0.425
A	96.09.16	NEW ISSUE
DESIGN DS		DRAWN BY PH
CHECKED #		APPROVED #
DATE 05.07.13		DART DART AEROSPACE LTD. HARRISBURY, ONTARIO, CANADA DRAWING NO. D2571 TITLE OUTER FWD SADDLE
		REV. E SHEET 1 OF 2 SCALE 2:1

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